

Date: Tuesday, 01/04/2008 3:46:03 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKIDTUBE ASSEMBLY
Job Number :	38279		
Estimate Number :	10022		
P.O. Number :		Part Number :	D205634011
This Issue :	01/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	/ /	Project Number :	N/A
Previous Run :	38278	Drawing Revision :	N/A
	Type :	Material :	
	LANDING GEAR	Due Date :	18/04/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JD 08.4.01		
Comment :	Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

08/04/22 08/4/17 JD

2.0	38279A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 38279

SP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------



(A)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	37288

8/4/22

SP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/22 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 38279

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: 0

FINAL INSPECTION/W/O RELEASE

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

Job Completion



MF 08-04-22

B38279A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 01/04/2008 3:46:25 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKID TUBE ASSEMBLY
Job Number :	38279A		
Estimate Number :	10023		
P.O. Number :		Part Number :	D205634041
This Issue :	01/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2580 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	38278A	Drawing Revision :	D
	Type :	Material :	
	LANDING GEAR	Due Date :	18/04/2008
Written By :		Qty:	1
Checked & Approved By :	<u>JD 08.04.01</u>	Um:	Each
Comment :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev: O 06.02.28 Added paperwork EC Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

2.0	D25001190	Ext'n -1' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	034729

JD 8-4-8

3.0	D2596	205 Web
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	038394

①
 JD 8-4-9
~~JD 8-4-8~~

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1

JD 8-4-8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38279A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/08 EL

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	m 107397	
Sikaflex expire date:		8-7-31	
Start Time:		3:30	Date: 8-4-8
Fin Time:			Date: 8-4-10

AWM
8-4-8

JK
8-4-8

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL / JD 8-4-10

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

JD 8-4-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38279A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/04/12

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	33321 BE 08/04/12

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	37856 BE 08/04/12

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m107263 BE 08/04/12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m107263 BE 08/04/12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

SL 8-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 01/04/2008 3:46:25 PM
User: Julie Lecocq

Process Sheet

30 min

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

16/04/2008

S.029 08.26

Job Number: 38279A

Part Number: D205634041

#1 324.7 F

Job Number:



#2 D205634041

#3 B38279A

#4

Seq. #: Machine Or Operation: Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08-04-15 / 08/04/15

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/15 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL

08-04-15

(X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

HL 08/04/16

(X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-17

(X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B37570

HL

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M100188

HL

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M104885

HL

08-04-17

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38279A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105855

JS

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M107376

JS

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M107376

JS

24.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

JS

25.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38298

JS

26.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B38048

JS

27.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37561

JS

08-04-17

(X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38279A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B37811

JS

29.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B37812

JS

30.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B38297

JS

31.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch: B29908

JS

32.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch: B37926

JS

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M107397

Sikaflex expire date: 08/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

JS 08-04-17

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38279A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 08/10

M1073973 08/04/17 (x1) JH

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M106894

m-l

08/04/17 (11)

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/04/18 (x1)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

38279

PPP Rev:

Rev 4

PPP 38279

8/4/22

50

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/23 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 382797

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RELEASED
07-06-28

Diagram illustrating the grinding locations on the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with the following specifications:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to a small circular feature on the left side of the main circle.
- AN3-SA BOLT (1)**: Points to a bolt passing through the center of the component.
- AN960JDTOL WASHER (1)**: Points to a washer on the bolt.
- (2 PLACES)**: Points to two small circular features on the right side of the component.
- D2855 CAP**: Points to the top surface of the component.
- SEAL WITH SIKAFLEX-241/-291**: Points to the outer edge of the component.
- 0.208**: Dimension for the diameter of the small circular feature on the left.
- 0.40**: Dimension for the diameter of the main circular component.
- 0.005**: Dimension for the thickness of the component.
- 0.002**: Dimension for the thickness of the washer.
- 0.001**: Dimension for the thickness of the cap.

D2579 SPACER

WEB (REF)

130 (REF)

AFTER PERFO

1. CHA
2. INS
3. WEI

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB

3.0

1.750

1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

REFER TO DETAIL A

0.5 1.5 1.5 D P P P P P P P

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

8

REFER TO DETAIL C

D3566-1 D3566-5 D3566-13

D3564-11 D3564-5 D3564-9





AN3C4A BOLT (1)
AN560C10L WASHER (1)
(50 PLACES)

DESIGN J DRAWN BY

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DESIGN		DRAWN BY	
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07.02.27			

 DART AEROSPACE LTD. HAINESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241/-291

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

SEE NOTE ii)

D2855 CAP

0.40

UN

Diagram illustrating the assembly of a circular web component. The diagram shows a circular web with a central cross structure. Labels point to various parts:

- D2579 SPACER
- D2596 WEB (REF)
- 7-1032-130 (REF) (TYP 50 PLACES)
- AFTER PERFORM

Steps for assembly:

1. CHA
2. INS
3. WE
4. C'B

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (20 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. C/BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP**

i) **FINISH:** ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

Technical drawing of a curved pipe section. The drawing shows a horizontal pipe with a curved end. Key dimensions and callouts include:

- Overall length: 51.340
- Distance from left end to first hole: 5.985
- Distance between first and second hole: 5.338 (REF)
- Distance from second hole to third hole: 39.580
- Distance from third hole to end: 5.915
- Radius of curvature: $\phi 0.508$ (8 PLACES)
- End radius: $\phi 0.640$
- End angle: 20.0°
- End height: 11.0
- Left end height: 1.4
- Callout 4 (triangle symbol) pointing to the left end.
- Callout 4 (triangle symbol) pointing to the end of the pipe.
- Dimension 1.0: DISTANCE BETWEEN HOLE AND TANGENT POINT (two locations).
- Dimension 13.4: Distance from left end to first hole (alternative measurement).
- Dimension 32.0 ± 1.0: Total length from left end to end of pipe.

[illegible]

AN3C4A BOLT (1)
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DESIGN

A

CHECKED

DATE _____

07.02.27

DRAWN BY

Rb

APPROVED

[illegible]**DART**

DRAWING NO
D2580

02580	
TITLE	

205 SKIDTUBE ASSEMBLY

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

10. <http://www.who.int/mediacentre/factsheets/fs104/en/>

REV. 0
SHEET 3 OF 3

SCALE

1:24

NO. 147

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 38305
Part number: D205 B4 041
Description: skid tube 205
Welding Process: Tig[☒] Mig[]
Base materiel: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dival. Date of Test Coupon 08-04-14
Welder Barclay Elliot Date of Test Coupon 08-04-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld